

Date: Wednesday, 2/15/2006 3:46:33 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FORWARD CAP
Job Number	: 25839		
Estimate Number	: 10501		
P.O. Number	: N/A	Part Number	: D2744
This Issue	: 2/15/2006 S.O. No. : N/A	Drawing Number	: D2744 REV B 1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B 1
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 3/15/2006 Qty: 30 Um: Each
Checked & Approved By	: <i>[Signature]</i> 06.02.16		
Comment	: Est C 03.01.17 Reformat; Dwg revised KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.1914 sf(s)/Unit Total: 5.7425 sf(s)  
 Material: 5052-H32 (QQ-A-250/8) or 6061-T6 (QQ-A-250/11) 0.080 thick.  
 Use off-cuts  
 M5052H32S.080) Batch *M19729*

*J.L 06.02.24*

2.0	SHEAR	SHEAR
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Comment: SHEAR *6.65"* *06.02.24*  
 Cut blanks: *(2.400 x 3.125")*

*J.L 06.02.24 30*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine per Folio FA309 and Dwg D2744  
 Deburr *SAD 06.02.27*

*J.L 06.02.24 30*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L 06.02.24 30*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J.L 06.02.24 30*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 06/02/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: FORWARD CAP

Job Number: 25839

Part Number: D2744

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA/LG

*Signature* 06-02-27 30

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Signature* 06/02/27

Job Completion



*Signature* 06-02-27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





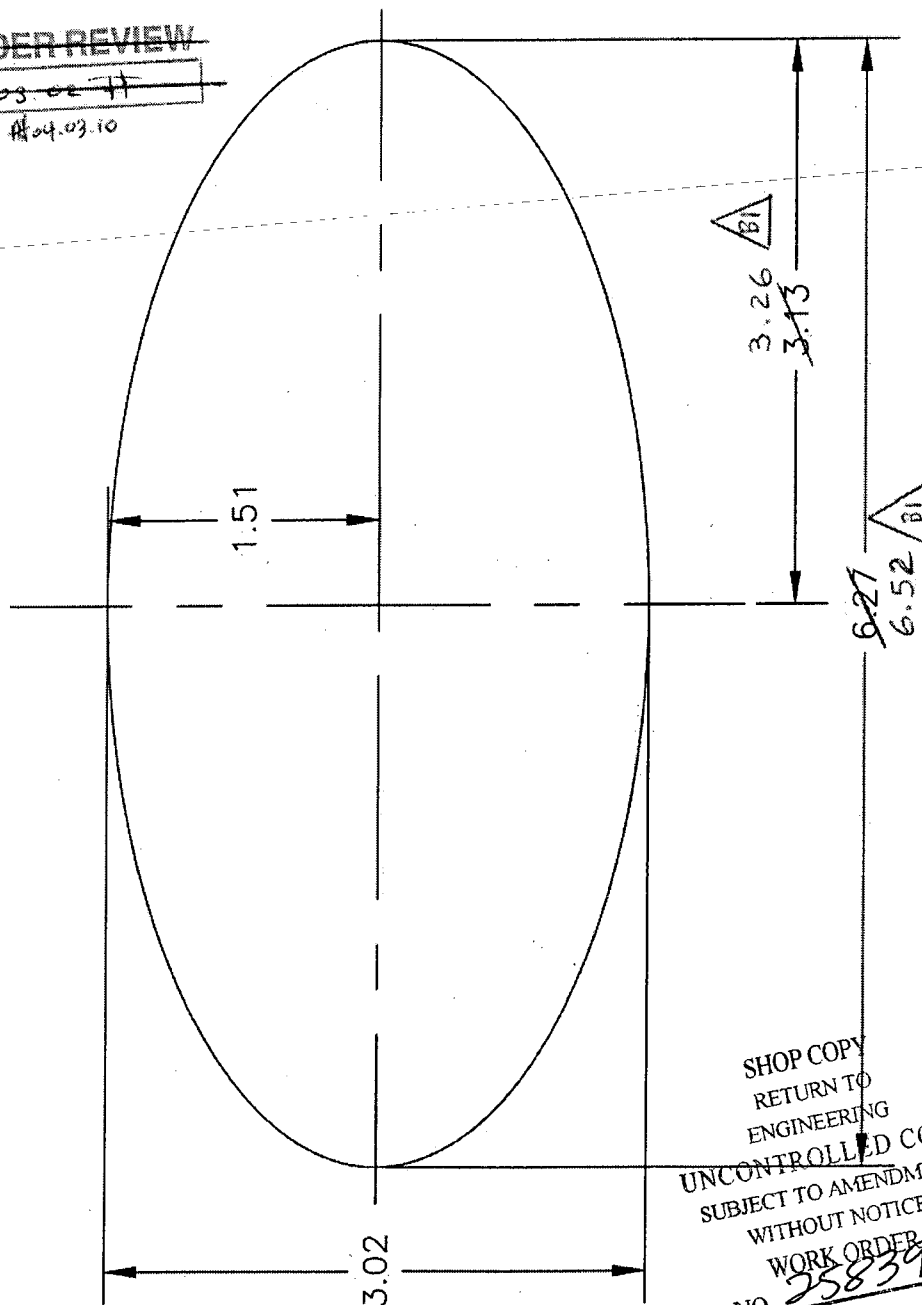
DESIGN <i>AF</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>AF</i>	APPROVED <i>AF</i>	DRAWING NO. D2744	REV. B SHEET 1 OF 1
DATE 02.12.18		TITLE CAP	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	02.12.18	REDESIGN	
Bi	<i>AF</i> 04.03.10	6.52 WAS 6.27 ; 3.26 WAS 3.13	

RELEASED  
02.12.18 *AF*

UNDER REVIEW

04.03.02 *AF*

OK *AF* 04.03.10



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25839

NOTES

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32 (QQ-A-250/8), 0.080 THICK (REF. DART SPEC M6061T6S.080 OR M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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